

Date: Wednesday, 15/04/2009 9:46:39 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 47178	
Estimate Number : 10952	
P.O. Number :	Part Number : D2562007
This Issue : 15/04/2009 S.O. No. :	Drawing Number : D2562 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 35173	Material :
Written By :	Due Date : 20/04/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09.04.15</u>	
Comment : Est A 04.05.10 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.9250 f(s)/Unit Total: 11.5498 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch M111704

FF 09-05-26 (6)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Punch to length as per Dwg D2562

FF 09-05-26 (6)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D"
 2- Deburr

FF 09-05-26 (6)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/05/26 (X6)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 7:30am
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 8:00am

JLD 09-05-27 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47178

Part Number: D2562007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

F-2 09/05/27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 264

9/5/27

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

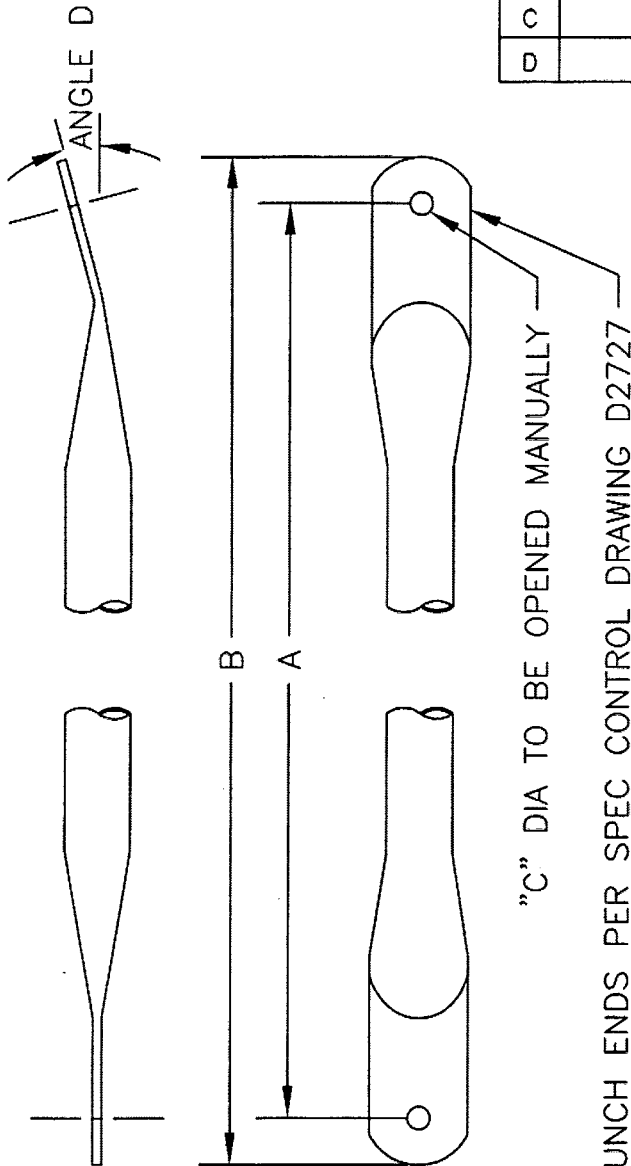
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47178

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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